

Work Order ID 119214

Tuesday, May 13, 2014 11:11:42 AM

119214

Page 1

Item ID: D3315-6

Revision ID:

Item Name: Wearplate RH Aft

Start Date: 5/14/14

Start Qty: 20.00

20

Required Date: 5/30/14

Req'd Qty: 20.00

20

Reference:

Approvals:

Process Plan: 

Date: 145-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3315	C

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut D3315-5F as per Dwg D3315

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

0.00

20

0

Jm14-05-20

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

20

0

Jm14-05-20

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

DAS
27
6-89

4/5/22

20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 119214

Tuesday, May 13, 2014 11:11:42 AM

119214

Page 2

Item ID: D3315-6 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate RH Aft
 Start Date: 5/14/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 5/30/14 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1- Form using DT8751 Die as per Dwg D3315 Rev: <u>AC</u> 2- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: <u>C</u>	0.00 0.00			DAS 30 9-89	<u>20</u>			<u>14/05/22</u>
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				<u>00</u>			
150 *150* Large Fab Large Fab	Large Fab Memo Weld hard surface using D3315-6T3 as per QSI 004 and Dwg D3315 Rev: <u>C</u> Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod <u>m124434</u>	0.00 0.00				<u>(20)</u>	<u>322</u>	<u>14-05-27</u>	

DQA: _____ Date: _____



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Tuesday, May 13, 2014 11:11:43 AM

1 19214

Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

20

Cust Item ID:

20

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

190

QC

Memo

0.00

Quality Control

DAS
27
9-8-9

14/5/30

200

0.00

200

Packaging

Packaging

Packaging

Memo

0.00

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-6, B/N: BXXXXX

For Product Eligibility see PDA05-17
and Stock

Location: ST500

DAS
28
9-89

JUN 20 2014

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLJ 14-06-03

ищ.0603

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

Tuesday, May 13, 2014 11:11:46 AM

Page 1

Work Order ID: 119214

119214

Parent Item: D3315-6

D3315-6

Parent Item Name: Wearplate RH Aft

Start Date: 5/14/14

Required Date: 5/30/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: A05.05.12New issue KJ/JLM
IPP Rev:B As per Rev B 06-03-24 JLM
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

390.3000

2

43

M1010S16GA

**

Jn14-05-20

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

390.3

124193

34

124254

0.3

124428

164

m129144

192

129144

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

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DART AEROSPACE LTD		Work Order:	119214
Description: Wearplate		Part Number:	D3315-5
Inspection Dwg: D3315	Rev: <i>CE</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

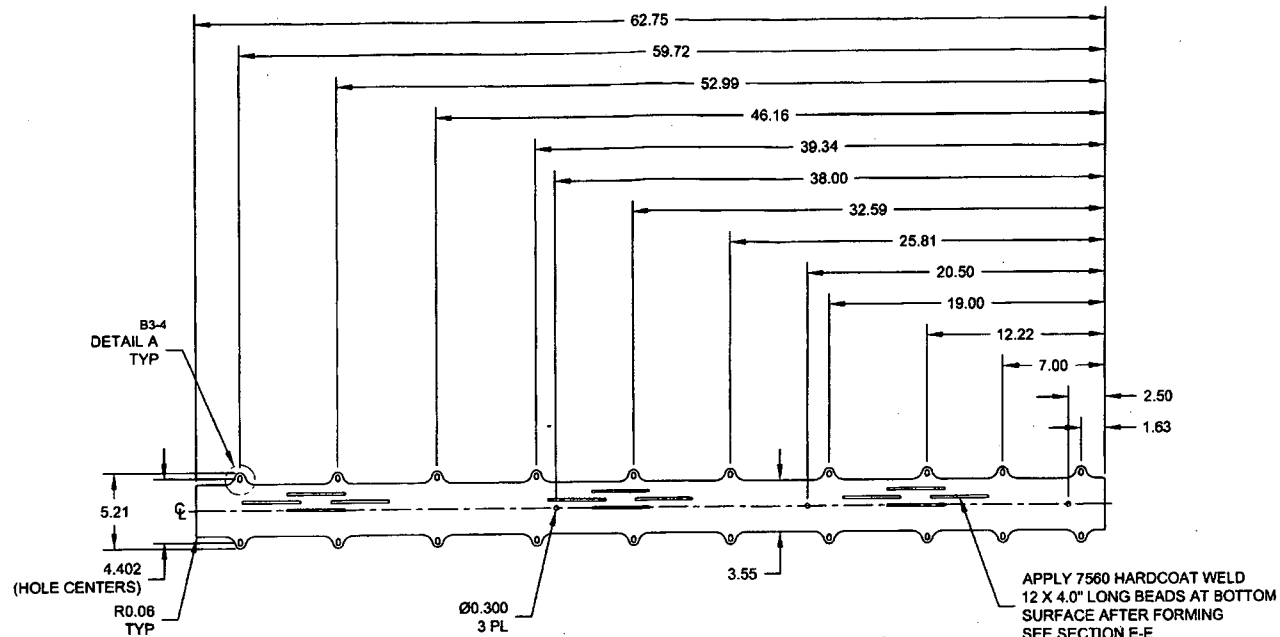
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31"	-		T	Jkmo7
30.215	+/-0.010	30.215"	-		T	
24.215	+/-0.010	24.215"	-		T	
21.611	+/-0.010	21.611"	-		T	
17.965	+/-0.010	17.965"	-		T	
16.026	+/-0.010	16.026"	-		T	
14.735	+/-0.010	14.735"	-		T	
12.815	+/-0.010	12.815"	-		T	
6.465	+/-0.010	6.465"	-		V	Jkmo5
5.464	+/-0.010	5.464"	-		V	
4.527	+/-0.010	4.527"	-		V	
3.550	+/-0.010	3.550"	-		V	
5.214	+/-0.010	5.214"	-		V	
Ø0.300	+0.006/-0.001	0.303"	-		V	
Ø0.266 x 0.575	+/-0.010	0.268 x 0.575"	-		V	
Ø0.266 x 0.450	+/-0.010	0.268 x 0.453"	-		V	

Measured by:	Jm
Date:	14-05-20

Audited by:	<i>27</i> S-49
Date:	14/5/20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD <i>KA</i>	<i>DA</i>



D3315-3F FLAT PATTERN
(D3315-3 SHOWN, D3315-4 OPPOSITE)



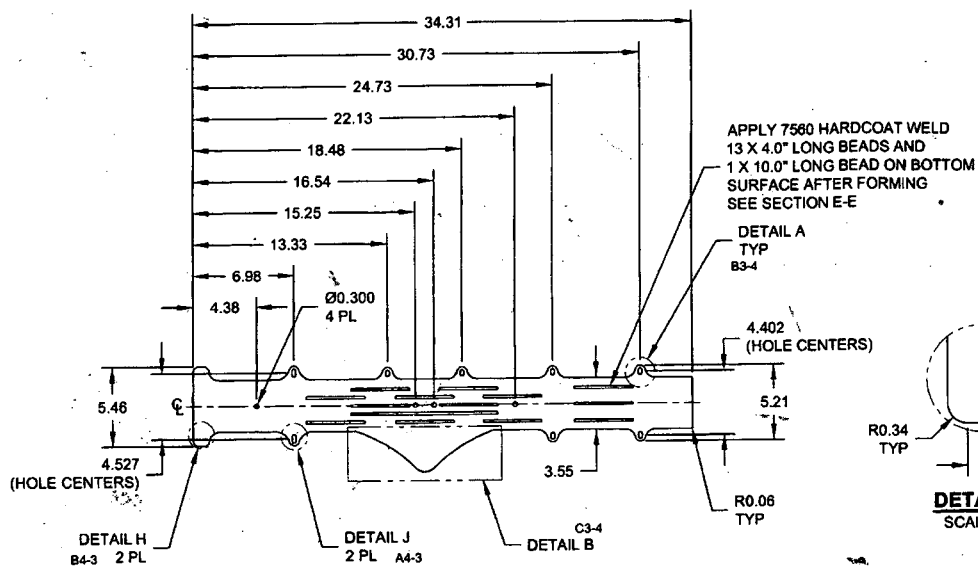
D3315-3/-4 WEARPLATE
MAKE FROM D3315-3F

D3315-3/-4/-3F NOTES:

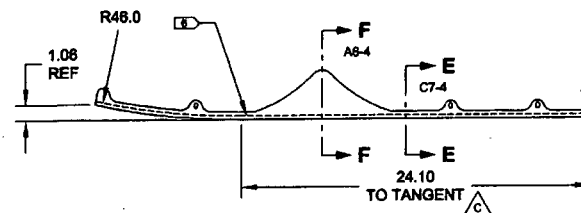
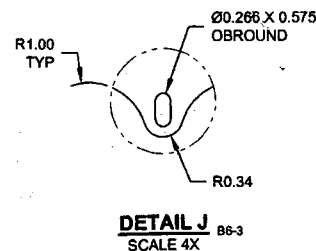
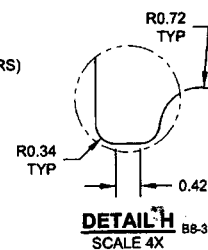
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 16 GAUGE (0.060 THICK) REF. DART SPEC. M1010GA16
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17" PER DART QSI 044 6.5 (LABEL)
- 7) WEIGHT: 4.15 lbs
- 8) WELDING: PER DART QSI 004
- 9) WATERJET PROGRAMMING: PER D3315-3F_REV.C.DXF

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	MS	D3315	SHEET 2 OF 4
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	WEARPLATE	NTS
DATE	13.01.22	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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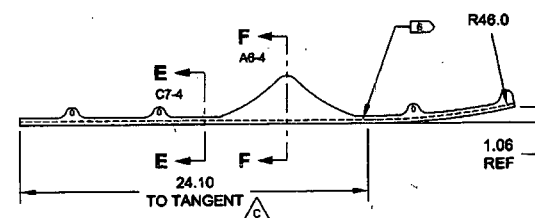
RELEASED
2013-02-16



D3315-5F FLAT PATTERN
(D3315-5 SHOWN, D3315-6 OPPOSITE)



D3315-5 WEARPLATE
MAKE FROM D3315-5F



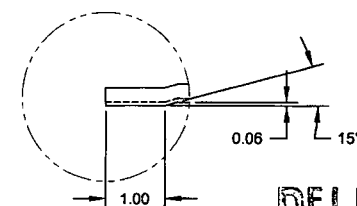
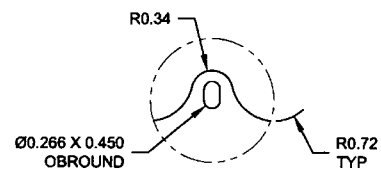
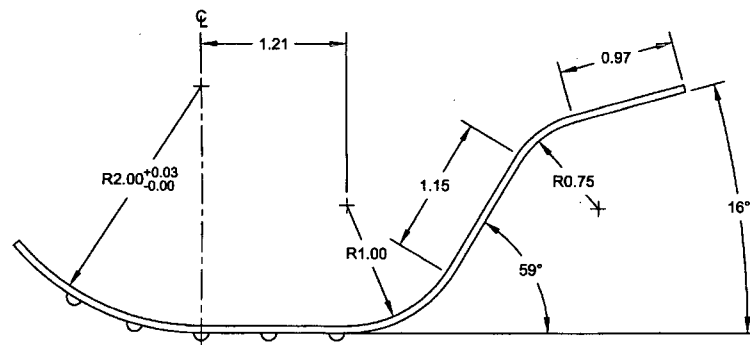
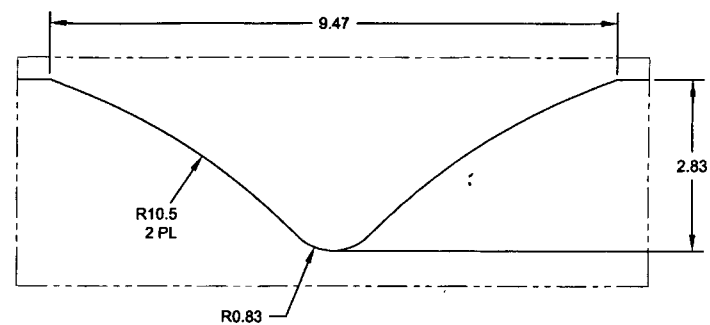
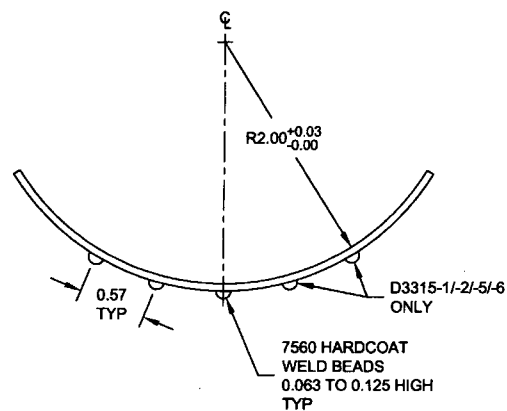
D3315-6 WEARPLATE
MAKE FROM D3315-5F

RELEASED
2013-02-14

D3315-5/-6/-5F NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 16 GAUGE (0.060 THICK)
REF. DART SPEC. M1010GA16
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH "TCCA-POA, DART AEROSPACE LTD., P/N D3315-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE POA05-17"
PER DART QSI 044 6.5 (LABEL)
- 7) WEIGHT: 2.15 lbs
- 8) WELDING: PER DART QSI 004
- 9) WATERJET PROGRAMMING: PER D3315-5F_REV.C.DXF

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DE APPR.		WEARPLATE	NTS
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CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3315	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	JP	WEARPLATE	NTS
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